

Work Order ID 61924-2

Thursday, September 09, 2010 12:54:21 PM

~~PRELIMINARY ISSUE~~



Page 1

Item ID: D4180-1

Revision ID: PRELIM

Item Name: Gusset

Accept



Setup Start



Stop



Start Date: 9/9/2010 Start Qty: 2.00

Required Date: 9/16/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Handwritten initials

Date: 10-9-09 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4180

PA1

0.00

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: *P.21*

Prog Rev: *PA1*

2-Deburr if necessary

0.00

10-9-13

(4)

QC2- Inspect parts off machine FAI/FAIB

0.00

110



QC

Quality Control

Memo

0.00

10-9-13

Work Order ID 61924

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Required Date: 9/16/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 - inspected to PA1 0.00 Dug only 8/10/2013 (x4)							
130 Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00 8/10/2013 (x4)							
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 - inspected to PA1 0.00 Dug only 8/10/2013 (x4)							

Work Order ID 61924

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Page 3

Item ID: D4180-1

Revision ID: PRELIM

Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00

Required Date: 9/16/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

150



HandFinish

Hand Finishing

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

⇒ M 10/09/10

4 0

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 10-9-10

④

4

170



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

composites

3
1

BT 10-10-01 (+3)

Work Order ID 61924

Thursday, September 09, 2010 12:54:21 PM



Page 4

Item ID: D4180-1

Revision ID: PRELIM

Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00

Required Date: 9/16/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10/10/04

BS10-01
3

POSITIVE RECALL

EFFECTIVE 10.09.08 AUTH A

RELEASED [Signature] DATE 10.10.01

PER RELEASED DWK

DATED 10.09.29

Picklist Print

Thursday, September 09, 2010 12:54:25 PM

Page 1

Work Order ID: 61924



Parent Item: D4180-1

Parent Item Name: Gusset

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased			No	100	sf	125.2600	0.191	0.402105			

M6061T6S.125

Purchased

No

100

sf

125.2600

0.191

0.402105



1810-9-13

6061-T6-125 Sheet

Location

Loc Qty

Loc Code

MAT21

125.26

113608

96

114352

29.26

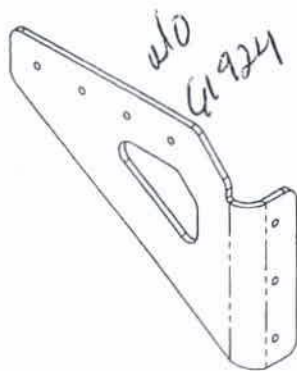
114 357

(4)

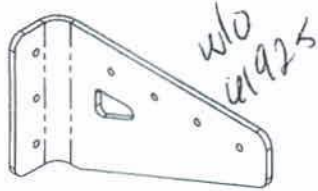
Rowe / Corn / Ax F

→ DOME

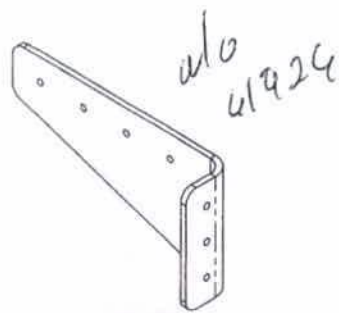
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D4180-1 GUSSET



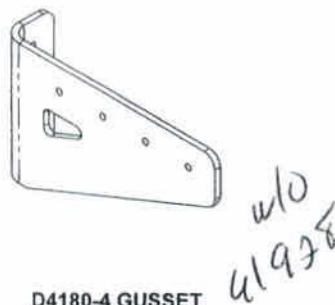
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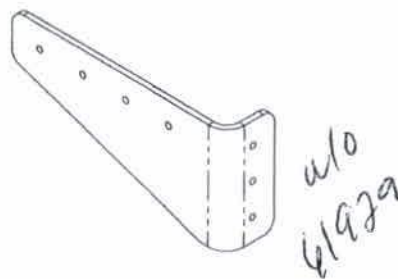
D4180-5 GUSSET



D4180-2 GUSSET



D4180-4 GUSSET



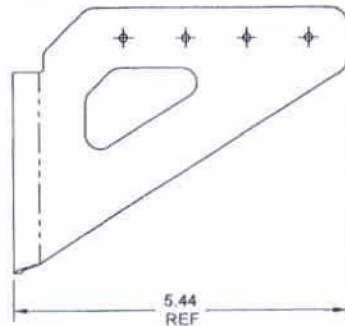
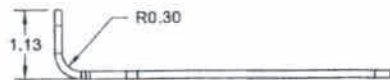
D4180-6 GUSSET

NO. 41927
10.9.09

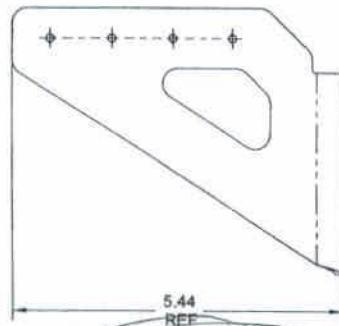
PRELIMINARY ISSUE
10.09.08

PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.03		

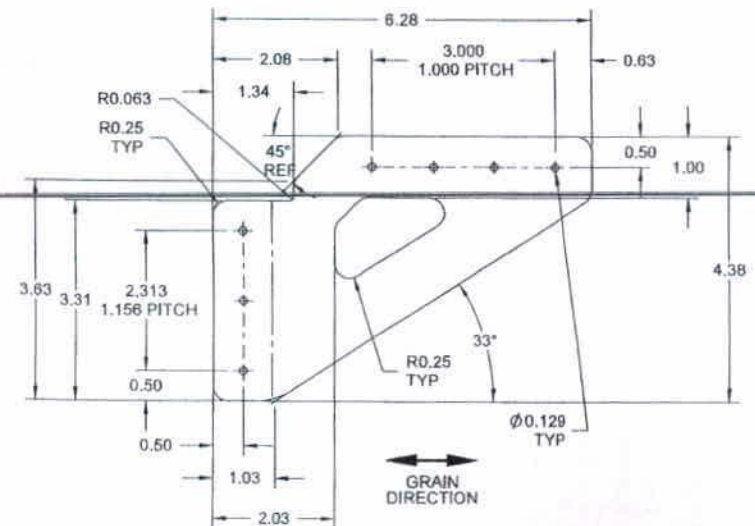
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4180	REV. PA1 SHEET 1 OF 4
TITLE POD FRAME GUSSETS	SCALE NTS
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D4180-2 GUSSET
MAKE FROM D4180-1F



D4180-1 GUSSET
MAKE FROM D4180-1F



D4180-1F GUSSET FLAT PATTERN

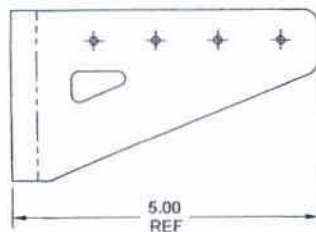
PRELIMINARY ISSUE
10.09.08

10/09/24

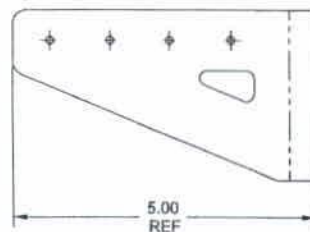
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs EACH

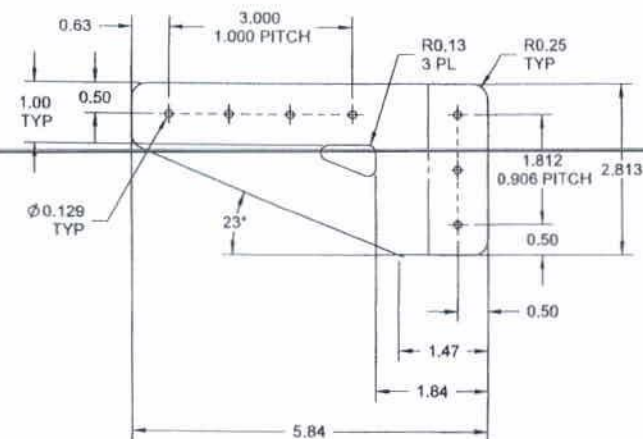
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4180	SHEET 2 OF 4
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DE APPR.		POD FRAME GUSSETS	NTS
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D4180-4 GUSSET
MAKE FROM D4180-3F



D4180-3 GUSSET
MAKE FROM D4180-3F



D4180-3F GUSSET FLAT PATTERN

w/b 61924

PRELIMINARY ISSUE

10.09.08

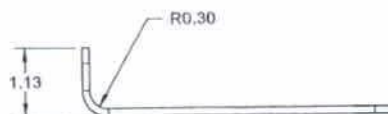
NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.15 lbs EACH

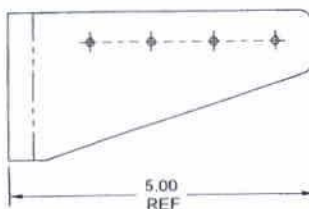
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4180	SHEET 3 OF 4
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8 7 6 5 4 3 2 1

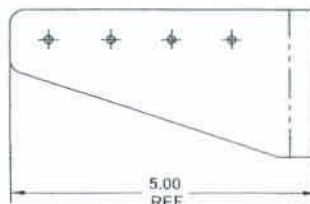
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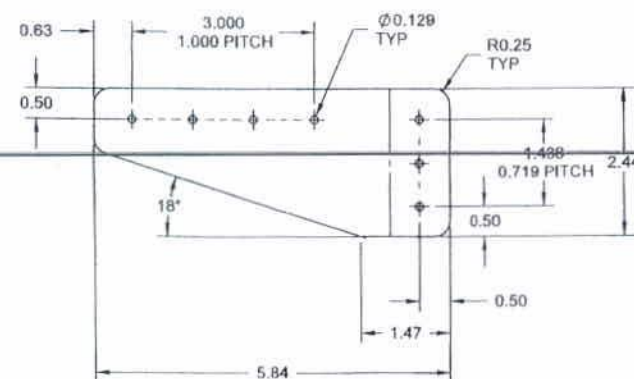
C



D4180-5 GUSSET
MAKE FROM D4180-5F



D4180-6 GUSSET
MAKE FROM D4180-5F



D4180-5F GUSSET FLAT PATTERN

B

w/060924

PRELIMINARY ISSUE
10.09.08

A

- NOTES:**
- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M8061T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.13 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA
MFG. APPR.		D4180	SHEET 4 OF 4
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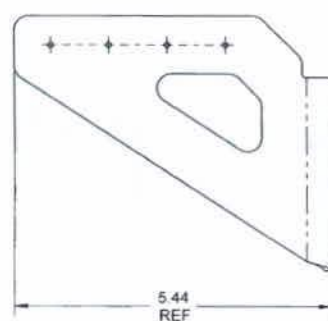
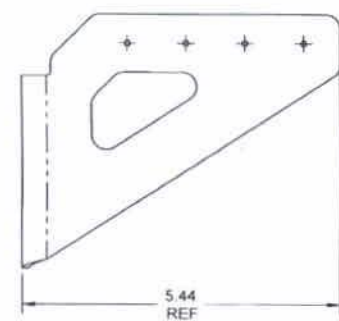
DART AEROSPACE LTD		Work Order: 6927
Description: GUSSET		Part Number: D4180-2
Inspection Dwg: D4180-2 Rev: 9A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

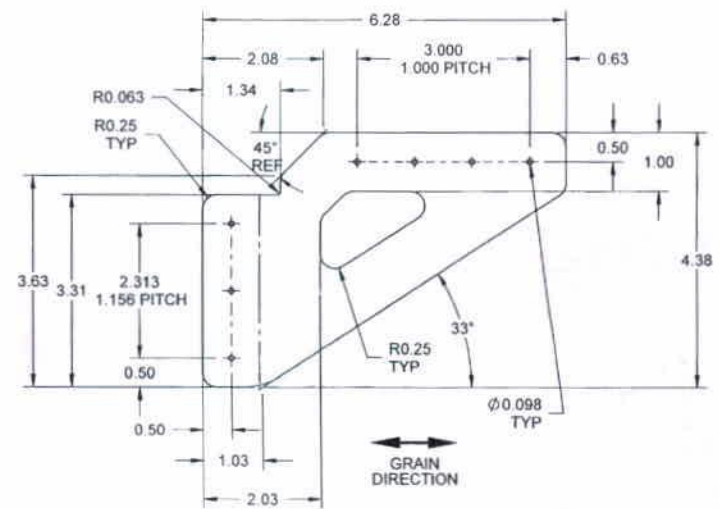
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.129	x		V 1802	
1.34	± .030	1.337	x		V	
2.08	± .030	2.08	x		V	
3.000	± .010	3.000	x		V	
1.000	± .010	1.000	x		V	
.63	± .030	.630	x		V	
6.376	± .030	6.379	x		V	
.50	± .030	.501	x		V	
1.00	± .030	1.000	x		V	
4.38	± .030	4.383	x		V	
2.03	± .030	2.038	x		V	
1.03	± .030	1.035	x		V	
.50	± .030	.497	x		V	
2.313	± .030	2.315	x		V	
1.156	± .010	1.154	x		V	
3.31	± .030	3.316	x		V	
3.63	± .030	3.633	x		V	
.123	± .010	.123	>		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-9-13	Date: 10/09/13	Date:	N/A
inspected to Part Draw only		Revised by: KJ/JLM	Approved:
Rev A	Date	Change	
		New Issue	



D4180-2 GUSSET
MAKE FROM D4180-1F

D4180-1 GUSSET
MAKE FROM D4180-1F



D4180-1F GUSSET FLAT PATTERN

- NOTES:**
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 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.19 lbs EACH

DESIGN	J	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	J	D4180	SHEET 2 OF 4
APPROVED	J	TITLE	SCALE
DE APPR.	J	POD FRAME GUSSETS	NTS
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6A24

RELEASED
2010-09-29